

Date: Friday, 05/01/2007 11:31:19 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HIGH AFT X-TUBE 412
Job Number	: 30191	Part Number	: D412664203
Estimate Number	: 10559	Drawing Number	: D412-664-243 REV C
P.O. Number	:	Project Number	: N/A
This Issue	: 05/01/2007	Drawing Revision	: C
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 15/02/2007 Qty: 1 Um: Each
Previous Run	: 30190	Type	: LANDING GEAR
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM est rev G 06.12.08 per ECN 886 EC		

Additional Product

Job Number:



SICP

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D412-664-203 CHG 005
2.0	D6009129	Crosstube Material
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D6009-129 Crosstube <i>25668</i> Check OD = 3.500"; ID = 2.250" <i>M8 07.01.10</i>
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
		Comment: MORI SEIKI CNC LATHE LARGE 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166 2-Turn first side as per Folio FA166 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243. <i>BG 07.01.10</i>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET <i>BG 07.01.10</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/01/2007 11:31:20 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30191

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE

Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3- Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243
engrave on outside of tube)

Inside of Cuff(Donot

BG 07.01.10

6.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

BG 07.01.10

7.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SD 07.01.10

8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

2-1-11

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 7-1-15 ①

11.0	QC3/5	INSPECT WORK/WING WALK
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Comment: Inspect work & Chemical conversion Coat

2-1-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 QA: N/C Closed: _____ Date: _____

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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30191

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

DP/EL 2-3-8

(ML)

13.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

14.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

15.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: _____ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/08	120	Tube was overbent in the mid section, and then over bent on the bottom. Tube doesn't fit into #4 on the sig.	MS 07/03/08	Scrap, will not be good for installation. Destroy !!!	DS 29-9 07/07/08	DS 07/07/08	MS 07/03/08	DS 07/03/08
				Scrap				

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30191

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
19.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Inspect for transit damage Ensure copy of NDT results attached to work order.</p>		
<p>Comment: Inspect for damage & ensure results are as per Dwg D412-664-203</p>		
20.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: SPRAY PAINTING</p>		
<p>1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2</p>		
22.0	QC14	Inspect Spray Paint
<p>Comment: Inspect Spray Paint Wrap in plastic bag to protect from scratches</p>		
23.0	D2856600	Abrasion Strip
<p>Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s) Pick: Qty Part number Description Batch 2 D2856-600(Cut to 10.090") Abrasion Strip _____</p>		
24.0	D28961	Support
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D2896-1 Support _____</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30191

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
25.0	D31891	Chafing Shield
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick: Qty Part number Description Batch		
	2 D3189-1	Chafing Sheild _____
26.0	MS2192028	Clamp(per MIL-DTL-8783C)
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Qty Part number Description Batch		
	4 MS21920-28	Clamp _____
27.0	MS2192032	clamp(per MIL-DTL-8783C)
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
clamp(per MIL-DTL-8783C) batch:		
28.0	D2732	Rubber Extrusion
Comment: Qty.: 1.0290 f(s)/Unit Total : 1.0290 f(s)		
Rubber Extrusion		
Cut qty 2 5.80" long		
qty part # description batch		
	2 D2732-058	rubber cushion _____

29.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

Instal support with magnobond 6398 per dwg D412-664-203,
cure for 12hrs before packaging.

Time & date of application: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30191

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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30.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

31.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0	AN640A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: _____

33.0	AN641A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: _____

34.0	AN960JD616	Washer
------	------------	--------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: _____

35.0	MS21042L6	Nut
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: _____

36.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 30191

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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37.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging: _____

Location: _____

PPP Rev: _____

38.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 04/09/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30191
Description: Crosstube Assembly (412 High Aft)	Part Number:	D412-664-243
Inspection Dwg: D412-664-243 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.688	✓		
	2.748	+0.005/-0.000	2.753	✓		
	2.884	+0.005/-0.000	2.888	✓		
	3.019	+0.005/-0.000	3.024	✓		
	3.163	+0.005/-0.000	3.167	✓		
	3.308	+0.005/-0.000	3.312	✓		
	3.429	+0.005/-0.000	3.434	✓		
	2.990	+0.005/-0.000	2.994	✓		
	2.618	+0.005/-0.000	2.623	✓		
	0.200	+/-0.010	.200	✓		
	R0.063	+/-0.010	.063	✓		
	R0.500	+/-0.010	.500	✓		
	4.971	+/-0.001	4.971	✓		
SIDE B	2.684	+0.005/-0.000	2.687	✓		
	2.748	+0.005/-0.000	2.751	—		
	2.884	+0.005/-0.000	2.887	✓		
	3.019	+0.005/-0.000	3.023	✓		
	3.163	+0.005/-0.000	3.167	✓		
	3.308	+0.005/-0.000	3.311	✓		
	3.429	+0.005/-0.000	3.432	✓		
	2.990	+0.005/-0.000	2.993	✓		
	2.618	+0.005/-0.000	2.622	✓		
	0.200	+/-0.010	.200	✓		
	R0.063	+/-0.010	.063	✓		
	R0.500	+/-0.010	.500	✓		
	4.971	+/-0.001	4.971	✓		
	124.09	+/-0.020	124.09	✓		

Measured by:	BC	Audited by:	SA	Prototype Approval:	N/A
Date:	07.01.10	Date:	07.01.10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	JL

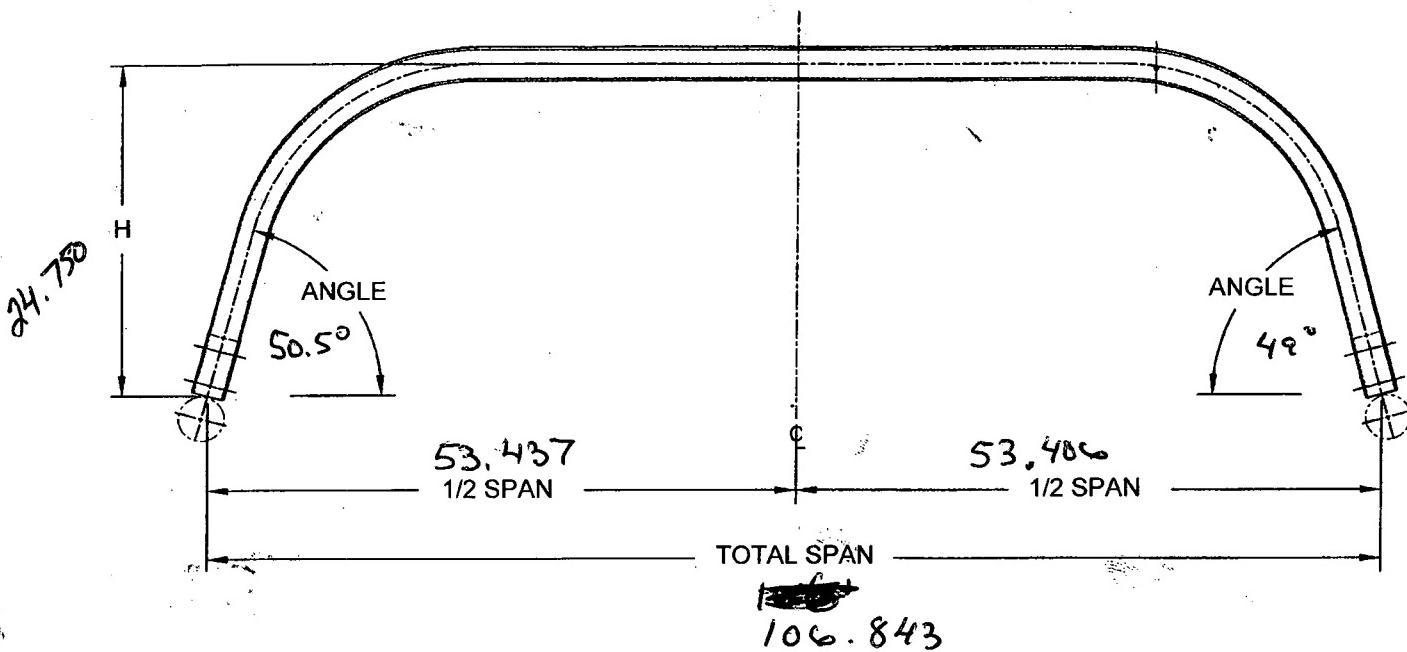
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Crosstube Bend Dimension Sheet



PART NUMBER: A412664203

BATCH NUMBER: 30191

DRAWING: A412664243 REVISION: C

H: 24.37

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50°

QC 15:

DATE: 07/03/08

QTY: 1

don't fit in table jig
over bent

SCRAP ~~07.03.17~~

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D412-664-243	REV. C SHEET 1 OF 3
DATE 06.10.27		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE NTS
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	

RELEASED*do 4-28 -H***PARTS LIST:**

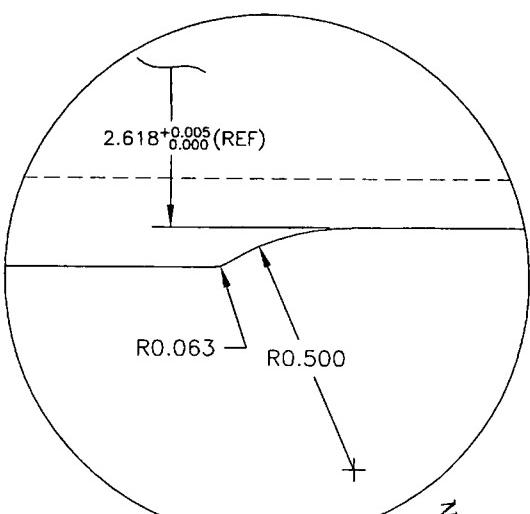
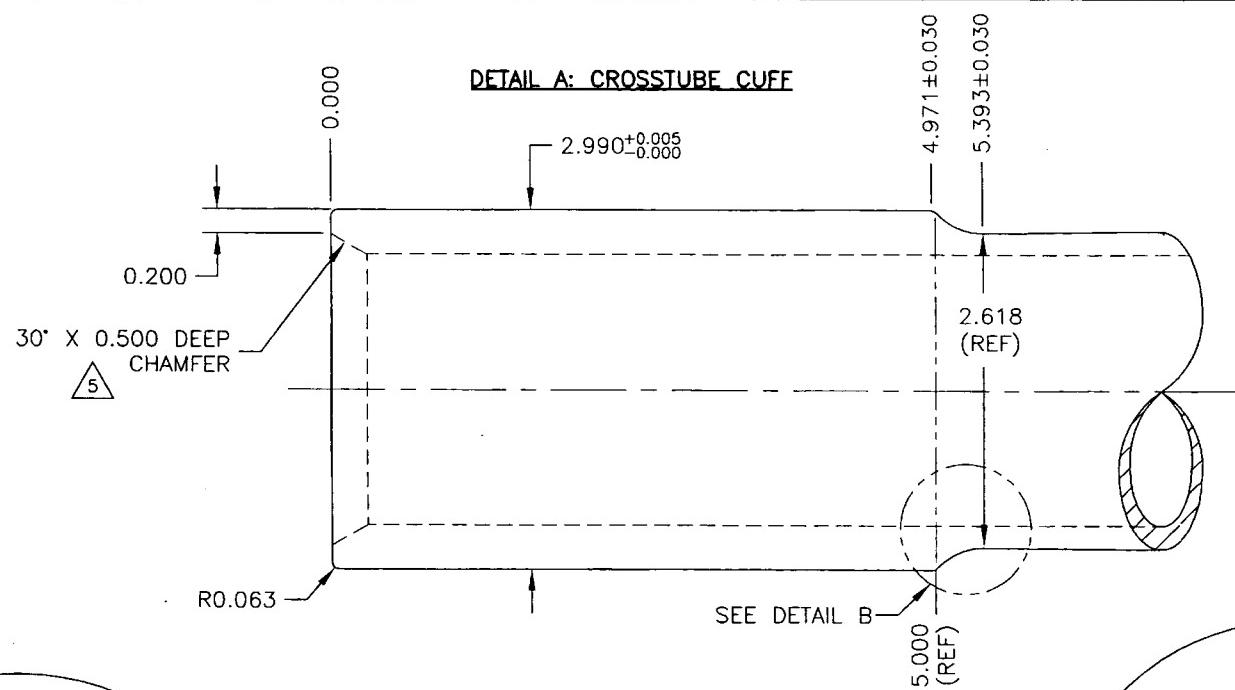
Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D2732-058	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-32	CLAMP
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09 ± 0.020
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
 - 4) PART IS SYMMETRIC ABOUT CENTERLINE.
 - 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
 - 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
 - 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
 - 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
 - 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
 - 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
 - 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR PACKAGING.
 - 12) INSTALL MS21920-32 CLAMPS WITH D2732-058 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
 - 13) TORQUE CLAMPS 80 TO 100 IN-LB.
- SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30191*

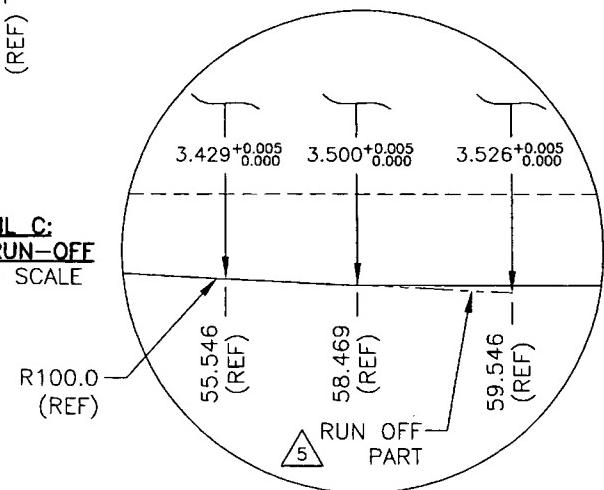
RELEASED
06.11.28

DETAIL A: CROSSTUBE_CUFF



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE

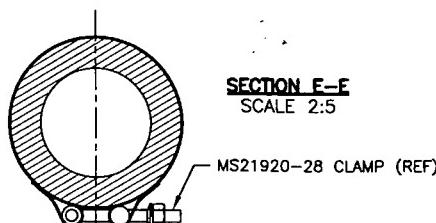
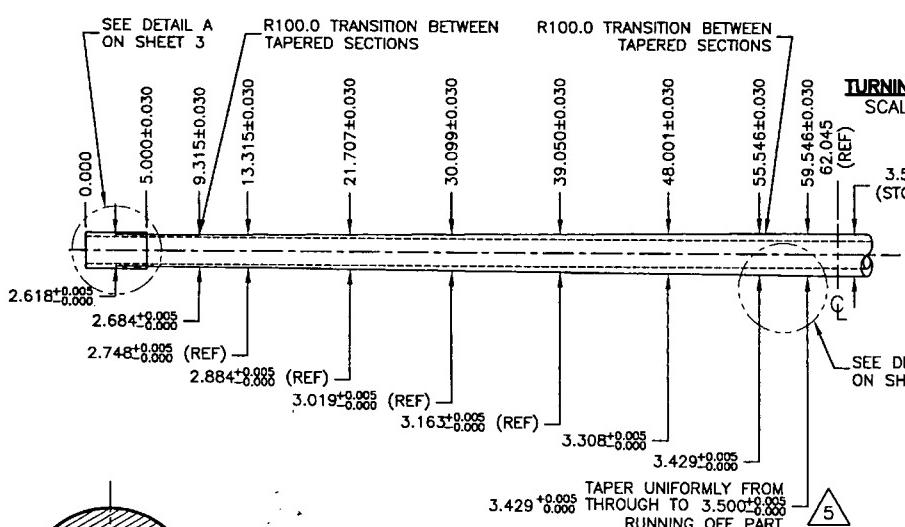
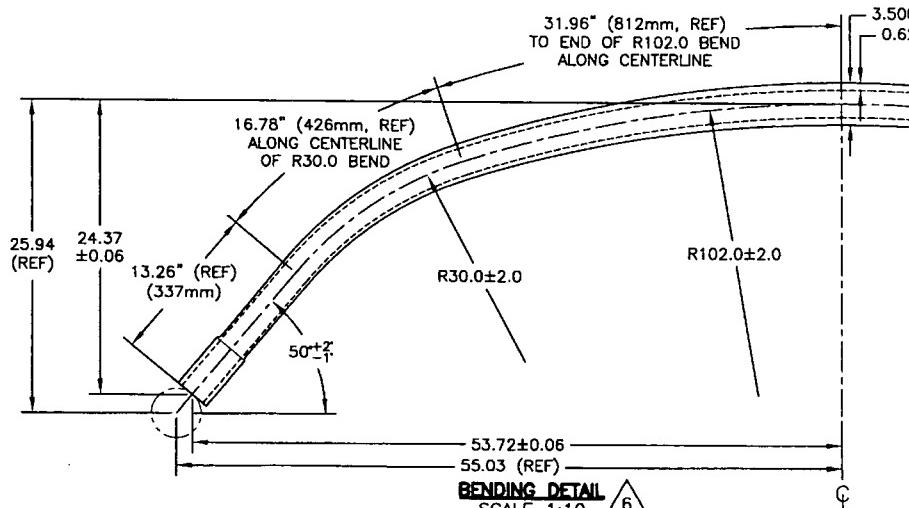


NO. 30121
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY

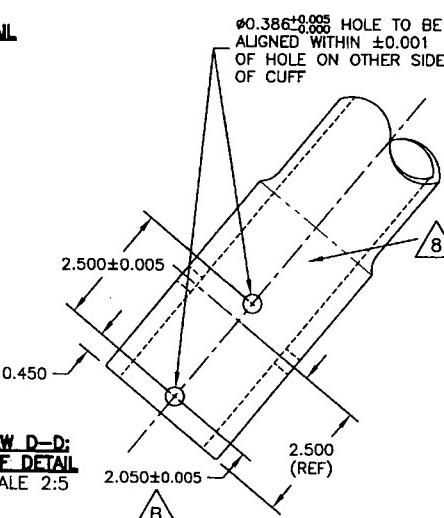
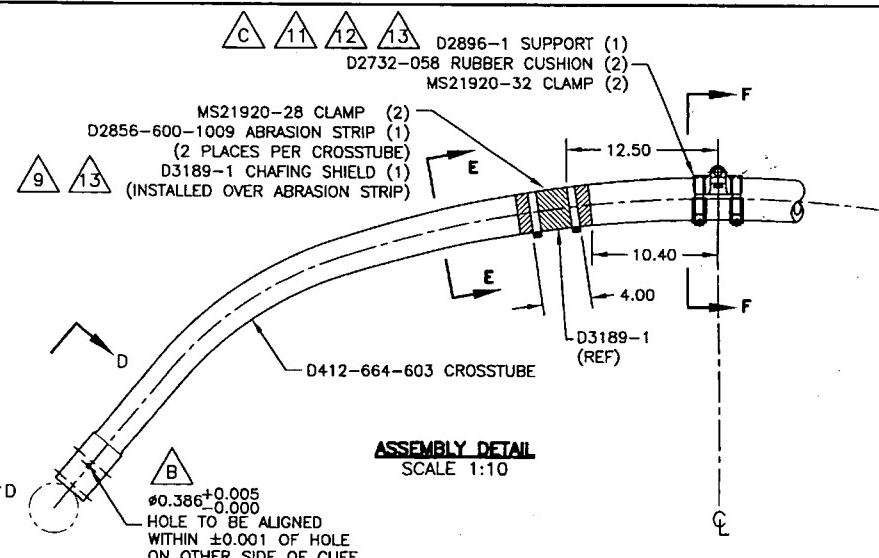
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RETURN TO
ENGINEERING

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
PH	AB	PH	REV. C DRAWING NO. D412-664-243 SHEET 3 OF 3
PH	APPROVED	PH	DATE 06.10.27
			TITLE CROSSTUBE ASSEMBLY (412 HI AFT) 1:1



UNCONTROLLED COPY
SUBJECT TO AN ENDMENT
WITHOUT NOTICE
WORK ORDER NO. 301-91
ENGINEERING
RETURN TO
SHOP COPY



COPRIGHT © 2001 BY DART AEROSPACE LTD.		DESIGN <i>PH</i>	DRAWN BY <i>BS</i>	DART	DART AEROSPACE LTD. NANSEBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>BS</i>			DRAWING NO. D412-664-243	REV. C
DATE 06.10.27				TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SHEET 2 OF 3 SCALE 1:10